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FIG.1

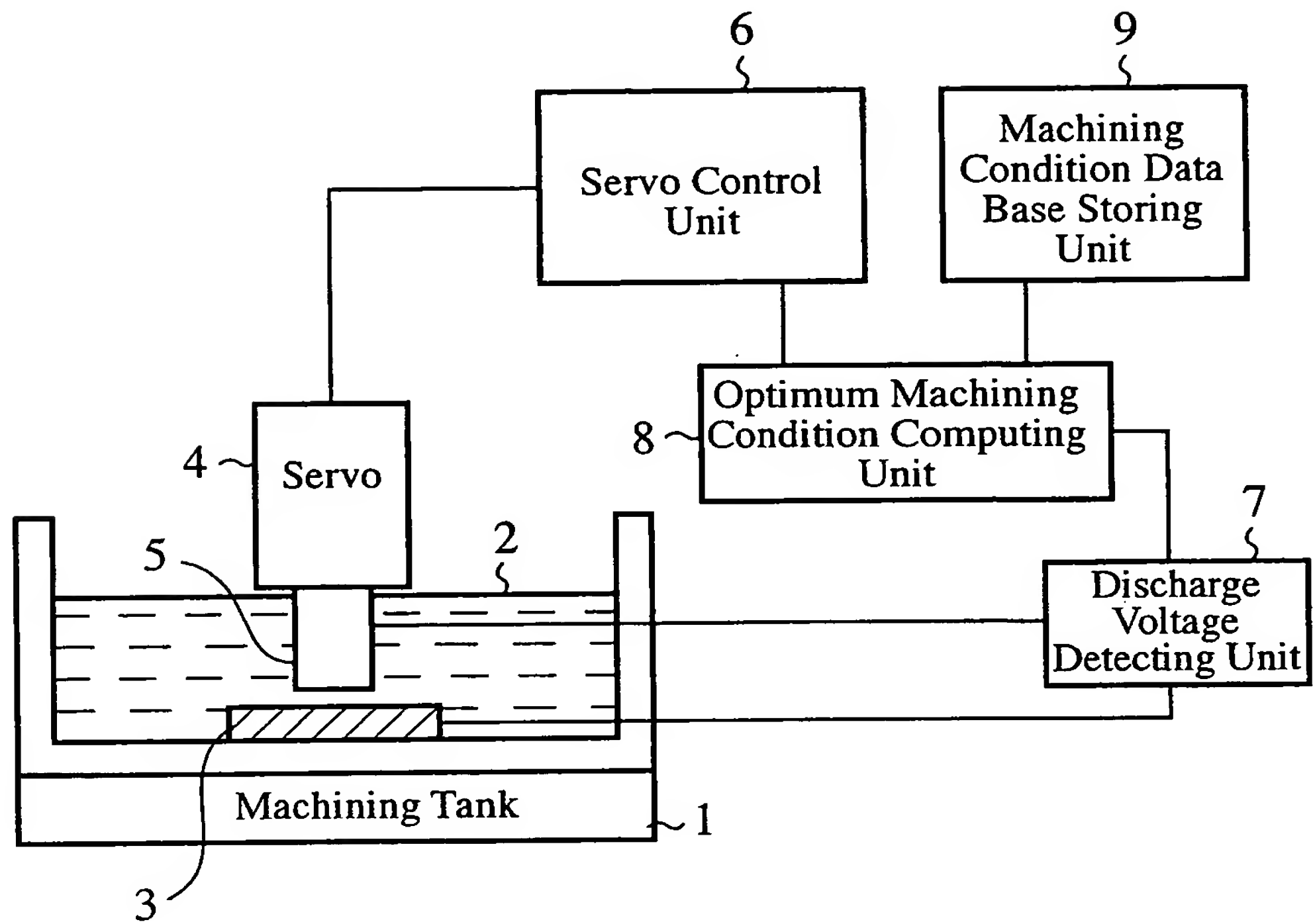
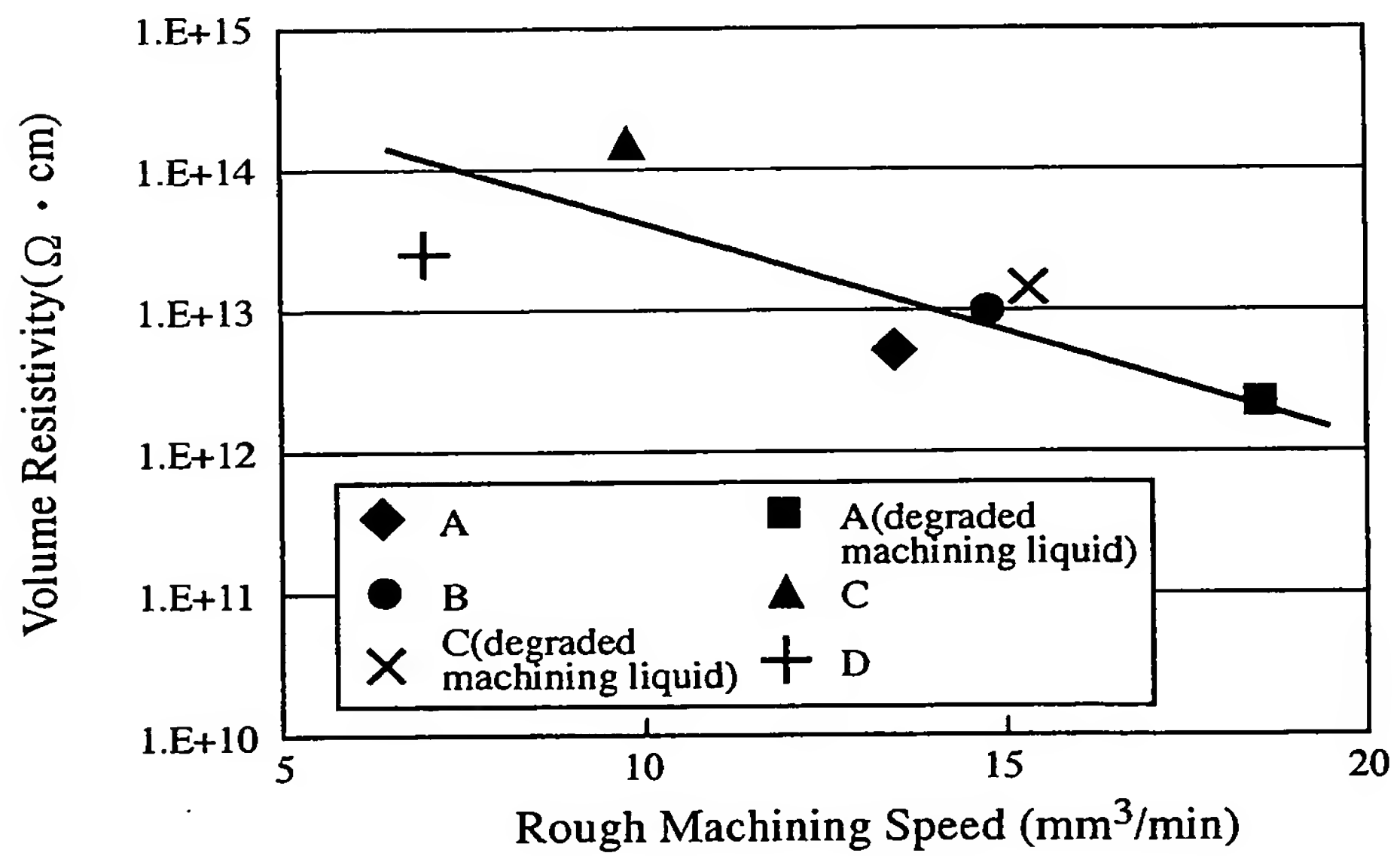


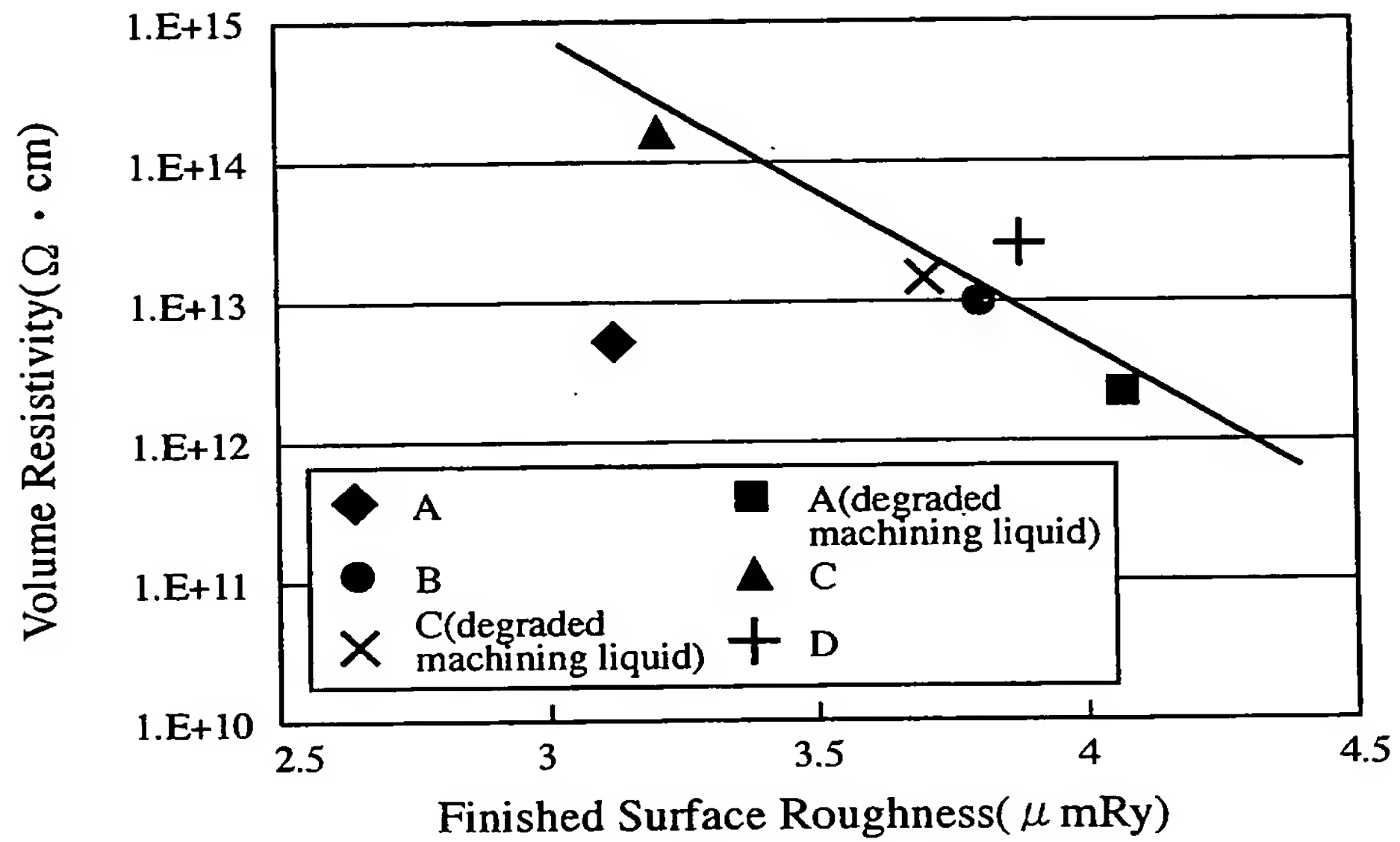
FIG.2



A : new machining liquid
A(degraded machining liquid) : used for three years
C : new machining liquid
C(degraded machining liquid) : used for one year

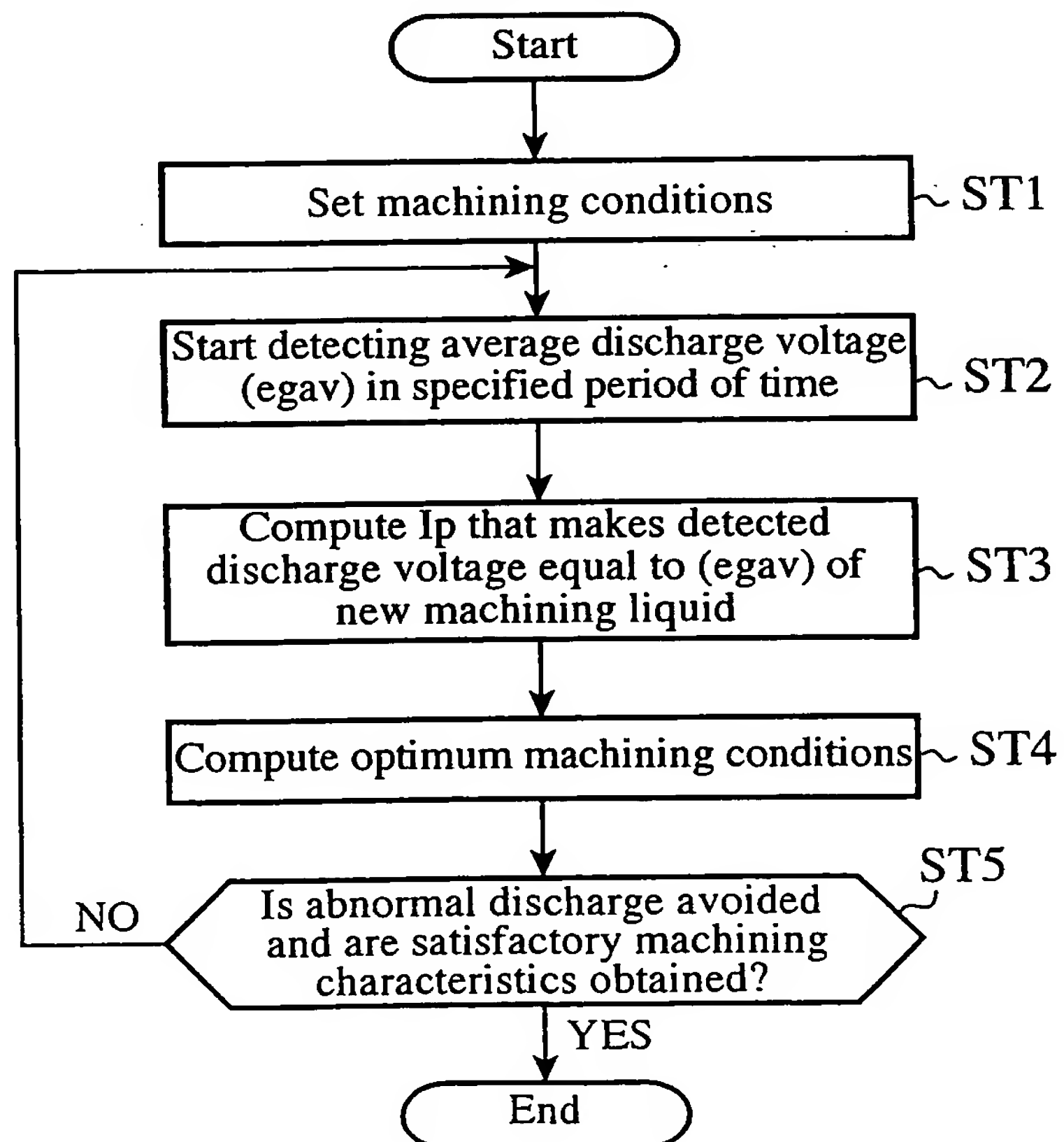
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FIG.3



A : new machining liquid C : new machining liquid
A(degraded machining liquid) : used for three years C(degraded machining liquid) : used for one year

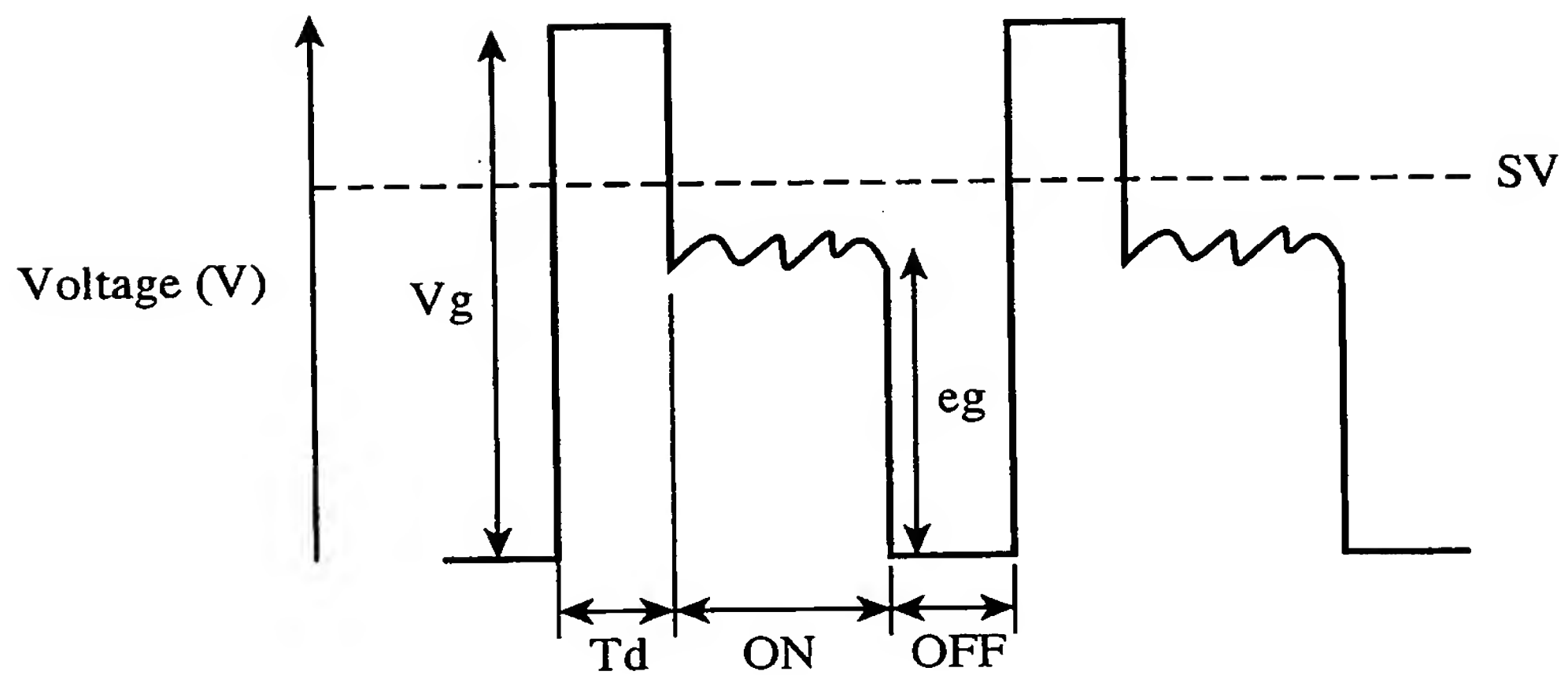
FIG.4



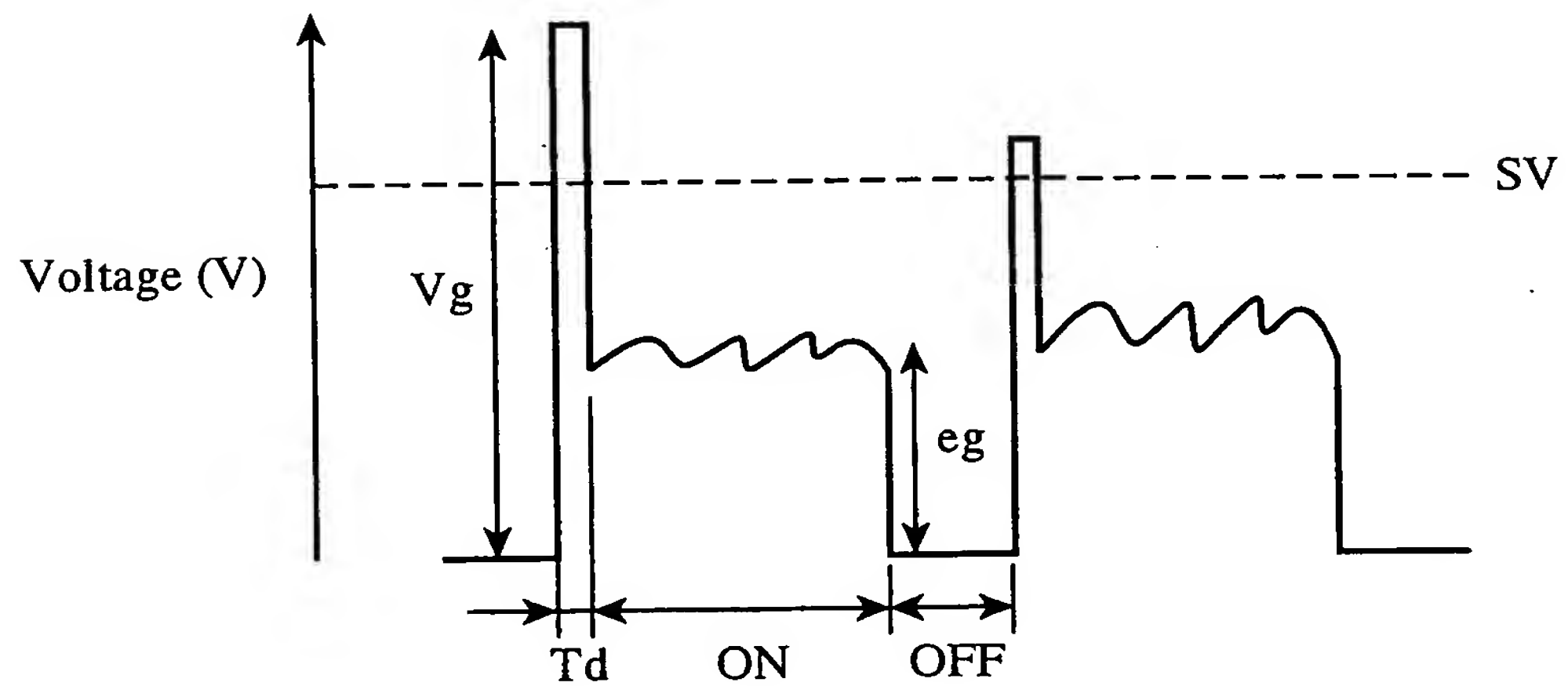
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FIG.5

(a) Normal electric discharge



(b) Abnormal electric discharge



V_g : no-load voltage
ON : discharging time
 T_d : no-load discharging time

OFF : non-operating time
 e_g : discharge voltage
 SV : servo reference voltage